

Date: Tuesday, 07/04/2009 2:26:16 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING
Job Number	: 47044		
Estimate Number	: 12075		
P.O. Number	:	Part Number	: PB6743001305
This Issue	: 07/04/2009 S.O. No. :	Drawing Number	: B6743001 PAGE41
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 42915	Material	:
Written By	:	Due Date	: 14/04/2009
Checked & Approved By	: <u>MF 09-04-07</u>	Qty:	<u>6</u> Um: Each
Comment	: Est. A 05.07.20 New issue KJ/JLM Est Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3R1750	2024-T3 Round Bar 1.750"
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Comment: Qty.: 0.3150 f(s)/Unit Total : 0.6300 f(s)
 2024-T3 Round Bar 1.750"
 Material: 2024-T3 Round Bar Ø1.750"
 (M2024T3R1.750)
 Identify for B67-43001-305
 Batch: M110063

mf 09/04/08

⑥

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN
 Turn as per Dwg B67-43001
 Dwg Rev: 31

mf 09/04/08

⑥

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 09/04/08

⑥

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

N.A 09/04/08

⑥

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

umd/ Fd.

09/04/09

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 2:26:16 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 47044

Part Number: PB6743001305

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



11 18 144



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask Ø1.260"

START TIME:

2:20pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:50pm

JH

09-04-18

(6)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fd 09/04/16

(6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST439A

SS

09/04/17

(x6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22

(12)

Job Completion



MF 09-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

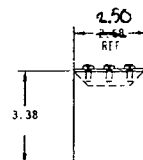
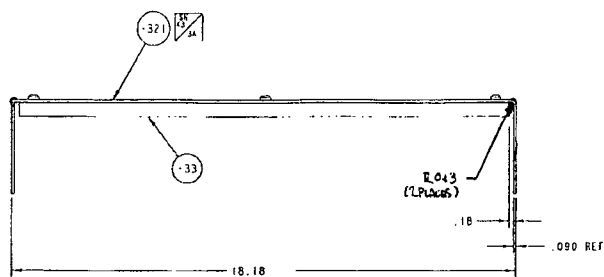
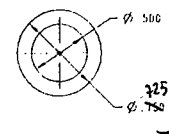
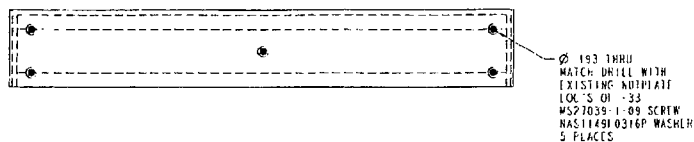
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

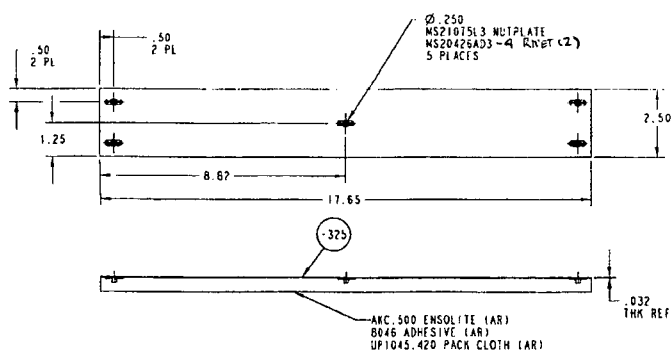
NOTE: Date & initial all entries

RELEASED
47044



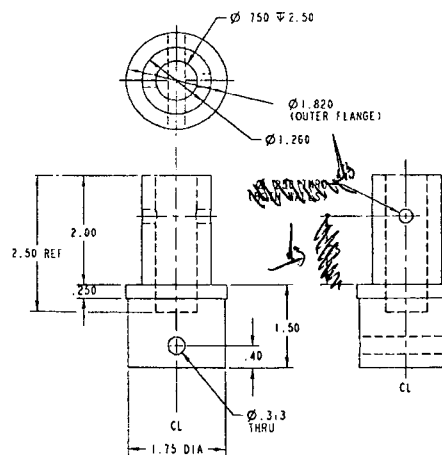
① -299 BUSHING
SCALE 2.000
MAT: 304 CRES. COND A

① -31 UPPER RESTRAINT WELDMENT
SCALE 0.500



47044

① -33 UPPER PAD ASSY
SCALE 0.500
MAT: FOR -325: .032 THK 2024-T3 AL.
00-A-25014



① -305 BEARING
SCALE 1.000
MAT: 2024-T3 AL.
00-A-20073

PREMIER AVIATION, INC.
9800 Aviation Parkway, Grand Prairie, Texas 75050
D105UV8 B67-430C1

ORIGINAL